

Work Order ID 51089



Page 1

July 30, 2009 4:04:06 PM

Item ID: D2332-045

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-31 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2332	Rev C1

100



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut to length as per Dwg D2332 (D2332-7) Locking Collar. Cut to length as per Dwg D2332 (D2332-5) Stop Pin. Deburr

(Signature)
M.F. 09/08/04

110



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch or form to length as per Dwg D2332 (D2332-21) using DT8012. Note:
Make (2) D2332-21 Prop Arms per assembly.)

(Signature)
M.F. 09/08/04

120



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill hole in D2332-21 as per Dwg D2332 using Drill Jig DT8459. Deburr.
(Drill 1 per assembly) 2-ensure no foreign objects inside fo tube and deburr

(Signature)
M.F. 09/08/04

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July 30, 2009 4:04:06 PM



Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

⇒ S 09.08.04

(40)

d

140



Large Fab

Large Fab

0.00

0.00

Large Fab

Memo

Weld D2332-21 and D2332-5 as per Dwg D2332 & QSI 004 using Welding Jig DT8298. (Weld 1 per assembly) Identify as D2332-23 ***** insure nothing is inside of tube before welding***** A/R SS Rod
 Batch: M109 Z13 *****brush weld r

09.08.04

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

A 09.08.04

Work Order ID 51089

Page 3

July 30, 2009 4:04:06 PM

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

**Set Up/
Run Hours**

0.00

**Draw
Number**

Rev.

**Plan
Code**

Qty

**Accept
Qty**

Qty

**Reject
Qty**

Number

**Reject
Number****Insp.
Stamp**

=> 509/08/04

(40)

6

170



Large Fab

Large Fab

0.00

Large Fab

0.00

Large Fab

Memo

Tumble

B 9-8-5

180



Small Fab

Small Fab

0.00

Small Fab

0.00

Memo

1-Tumble\2-Assemble as per Dwg D2332

B 9-8-5

L 509/08/05 ①

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Page 4

July 30, 2009 4:04:06 PM

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Stop



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Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

190



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

=> 8050805

(X)

f

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: S12

0.00

9/8/5 QD

0.00

210



QC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

J 0908-05

MF 09-08-05

A

Picklist Print

Page 1 / 3

July 30, 2009 4:04:06 PM

Work Order ID: 51089



Parent Item: D2332-045RevC1



Parent Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009

Required Date: 08/05/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A 		Purchased		No		180	Each	150.0000	1.0000		EJ 309/05/05	

Bolt

Warehouse

Location

Main Warehouse

ST	150	
101291	3	
106918	1	
108138	60	
111295	86	

AN960JD416L



Washer

Purchased

No

180

Each

641.0000 3.0000



EJ 309/08/05

Warehouse

Location

Main Warehouse

ST	641	
107008	54	
108138	4	
108583	42	
110153	541	

EJ 309/08/05

3

Picklist Print

Page 2

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Required Date: 08/05/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.250 		Purchased		No		110	f	24.8100	0.1140			

304 SS Round bar .250

WarehouseLocation

Main Warehouse

MAT

Loc Qty

Loc Code

m-h 09/08/04

107387

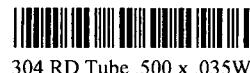
24.81

107387

24.81

M304TR0.500W.035

Purchased



304 RD Tube .500 x .035W

WarehouseLocation

Main Warehouse

MAT

Loc Qty

Loc Code

m-h 09/08/04

358.5862097

108250

2.23

111097

24.687936

111704

31.6682737

112187

300

M304TR1.000W.049

Purchased



304 RD Tube 1.00 x .049W

WarehouseLocation

Main Warehouse

MAT

Loc Qty

Loc Code

m-h 09/08/04

61.9900

108756

14.92

111457

47.07

M111457

Picklist Print

Page 3

July 30, 2009 4:04:06 PM

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Required Date: 08/05/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 		Purchased		No		100	Each	10,286.00	1.0000		<i>7/30/09/08/05</i>	

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

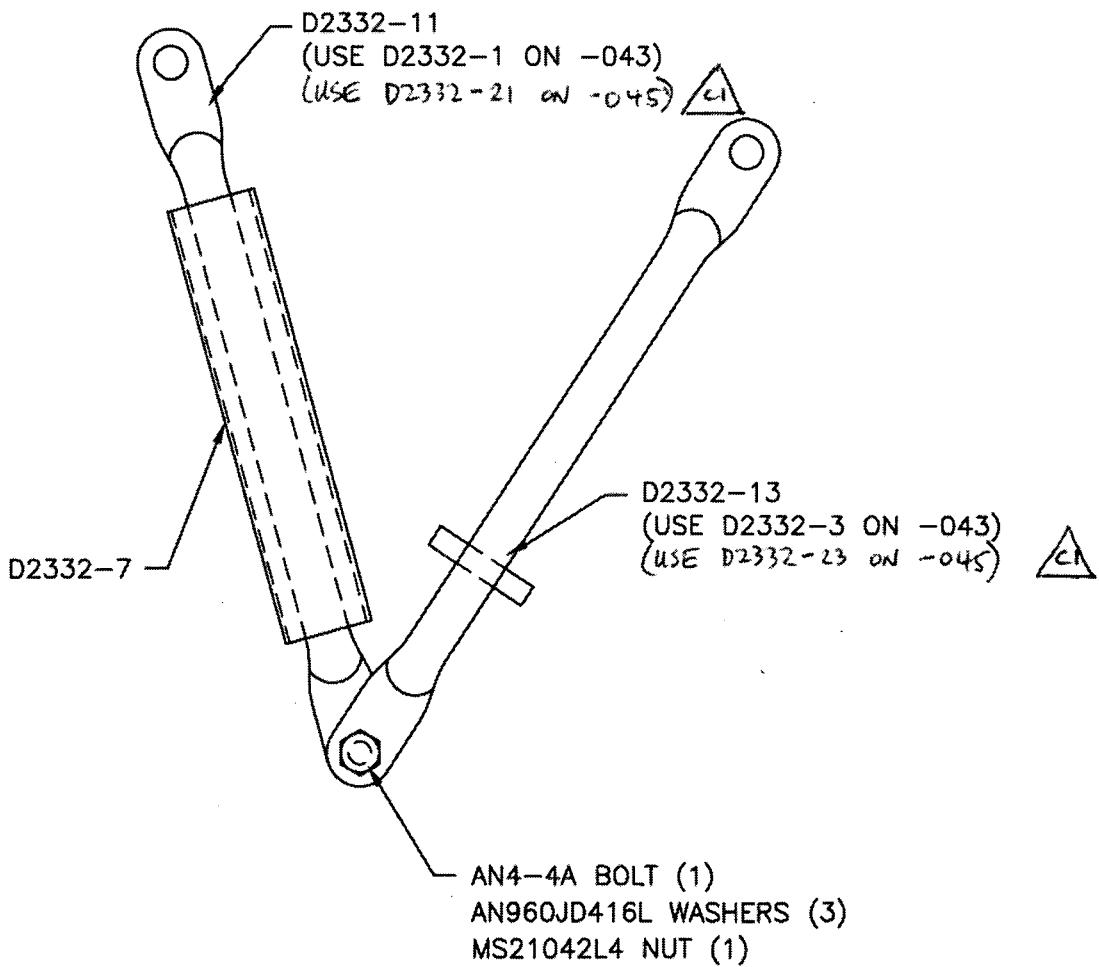
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107499	5	
110507	2240	
111827	6000	
112314	2000	
15924	0	
8182	41	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

DS 9
5/09-07
#



D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR)

CA

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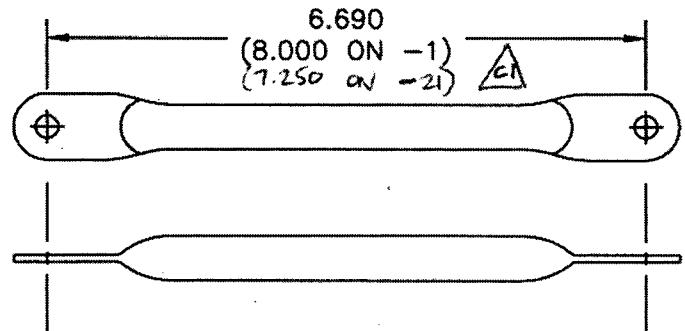
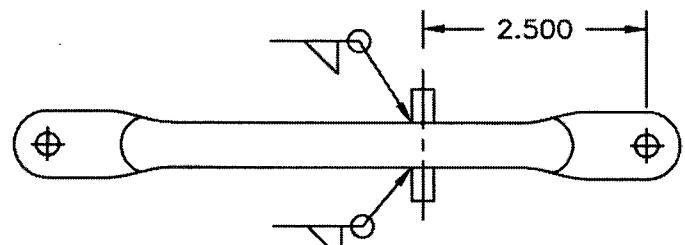
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DARTCOPY TO
CENS

DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>H</i>	<i>JF</i>	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
03.07.03	<i>H</i>	D2332
TITLE		SCALE
C	03.07.03	M A N E - 041 PROP 6.69" LONG (670) M A N E - 043 PROP 8.00" LONG (670)
C1	03.08.06	ADD - 045 Prop (7.25" LONG)

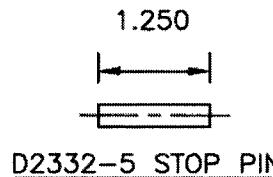
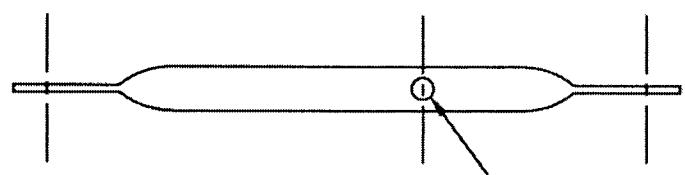
RELEASED

03.07.04

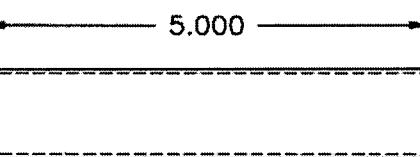
D2332-11 PROP
(D2332-1 SIMILAR)

D2332-13

M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

D2332-5 STOP PIN



D2332-7 LOCKING COLLAR

#51089
MF
09.07.31

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13